

Date: Monday, 18/08/2008 4:03:38 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: GASKET		
Job Number	: 41343				Part Number	: D3255		
Estimate Number	: 10431				Drawing Number	: D3255 REV B		
P.O. Number	:				Project Number	: N/A		
This Issue	: 18/08/2008		S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC				Material	:		
First Issue	: 18/08/2008		Type	:	PURCHASED PARTS	Due Date	: 25/08/2008	
Previous Run	: 36827						Qty:	54
Written By	:						Um:	Each
Checked & Approved By	: <u>JLD 08.8.18</u>							
Comment	: Est A 04.04.06 New issue KJ/RF							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>6982</u> Email or Ship DXF file to vendor Possible Supplier: <u>Beuco Inc.</u> <u>mcmaster</u> Material: Silicone coated fiberglass cloth per AMS 3320F P/N: SIL/F 36' x 36' x 1/16" certificat of conformaty required	<u>C208/08/19</u>  <u>54 SF</u>
2.0	SILF36X36X116	Gasket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 54.0000 Each(s) GASKET	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	 <u>P-08/08/09</u>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	 <u>8 08/08/28 X57</u>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST 468</u>	 <u>AS08/08/28 X84</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 4:03:38 PM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 41343

Part Number: D3255

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/029

Comment: Inspection Level 21

Job Completion



✓MF 08-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

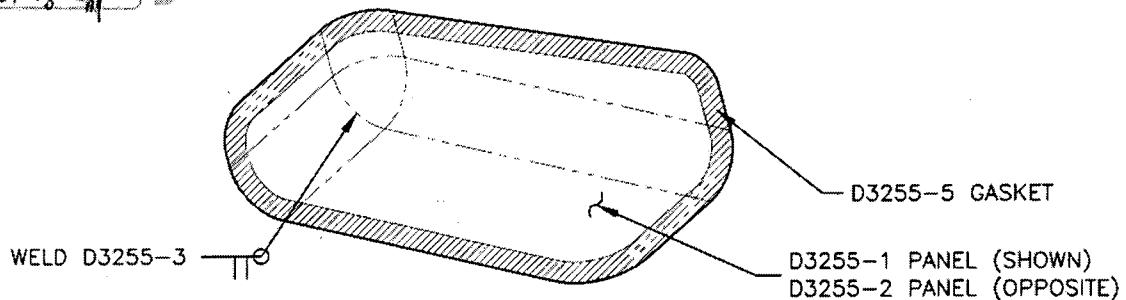
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

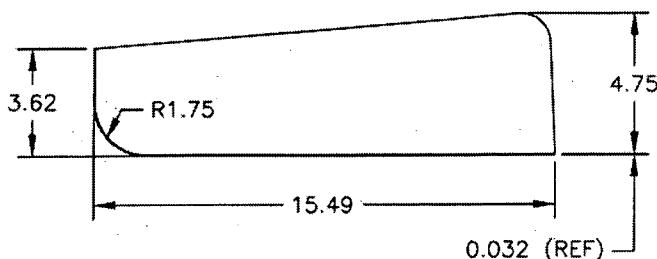
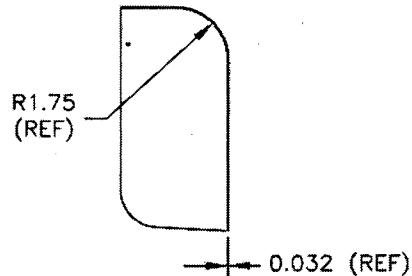
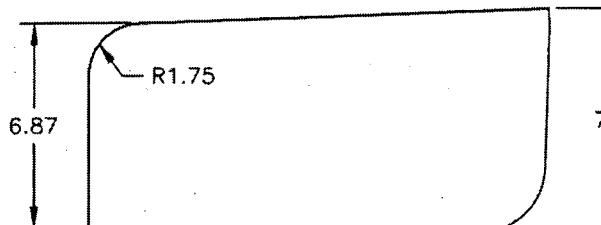


DESIGN <i>P</i>	DRAWN BY <i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>P</i>	APPROVED <i>S</i>	DRAWING NO. D3255	REV. B	SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6	
A	04.01.27	NEW ISSUE		
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098		

RELEASED  
05.01.18 *f*



D3255-041 ACCESS PANEL (SHOWN)  
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL  
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

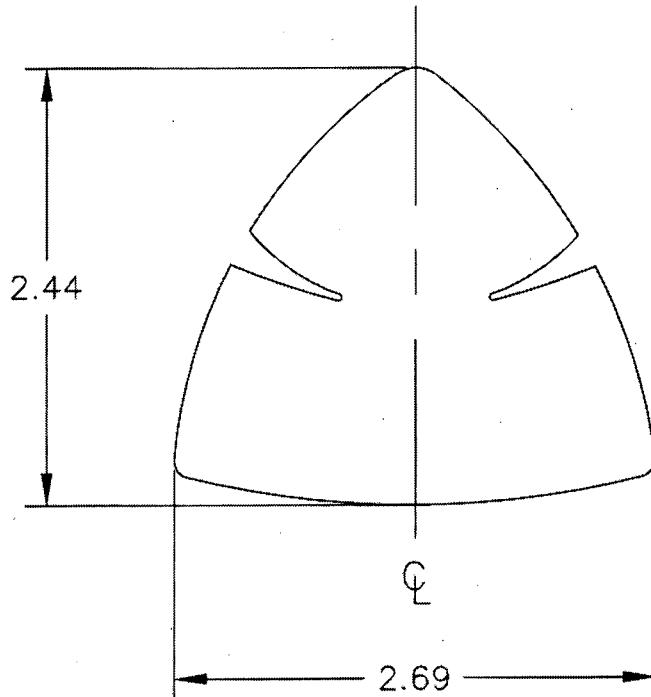
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *4137*



DESIGN DF	DRAWN BY DF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED <del>HF</del>	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06	TITLE	TITLE	SCALE 1:1

RELEASED  
05-01-18 HF



D3255-3 CAP  
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ENGINEERING
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

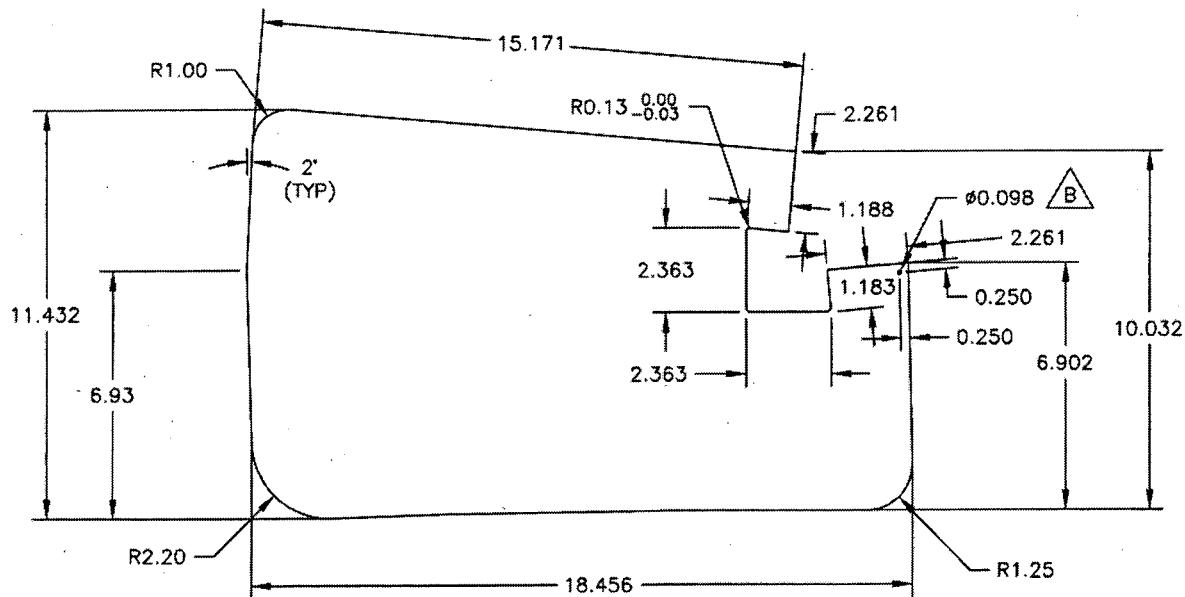
WORK ORDER

NO. 41343



DESIGN PF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



### D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE

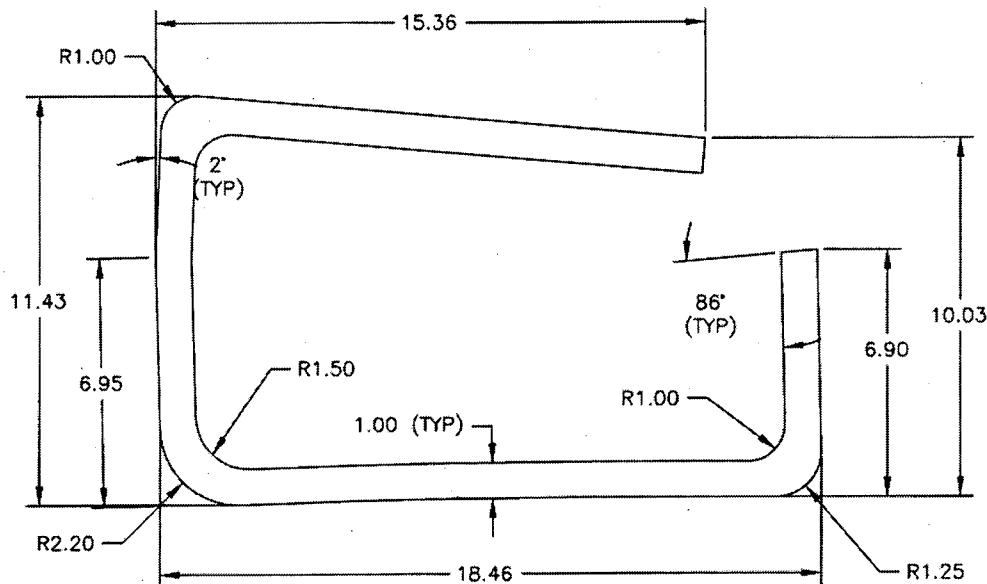
WORK ORDER

NO. 41343



DESIGN <i>TT</i>	DRAWN BY <i>TT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>TT</i>	DRAWING NO. D3255
DATE 04.12.06		REV. B SHEET 4 OF 4 TITLE ACCESS PANEL ASSEMBLY SCALE 1:5

RELEASED  
05.01.18 *TT*



### D3255-5 GASKET

#### D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *41343*



200 Aurora Industrial Pkwy  
Aurora, OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention: Main Finished Goods Location

Purchase Order  
PO00006982

McMaster-Carr Number  
**5252904-01**

Page 1 of 1

08/19/2008

Line	Description	Ordered	Shipped				
1	8612K61 Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	9	8 - 64 - 37 24 lbs	86 - 73	K61	9 EA

Dart Aerospace Ltd

**EXP**

Cycle

**48**

24 lbs  
1 line

FW1RFV8C  
08/19/2008  
13:24/14:20  
754



**McMASTER-CARR.**

200 Aurora Industrial Pkwy  
Aurora, OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention Main Finished Goods Location

Purchase Order  
PO00006982

Page 1 of 1

McMaster-Carr Number  
5252904-01

08/19/2008

Line	Description	Ordered	Shipped
1	8812K61 Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	8	9
		Each	

*S  
08/08/08*

**Certificate of Compliance**

This document certifies that according to our records, the material furnished on your purchase order was supplied in accordance with the description and illustration provided in our catalog.

*Lindsay Hirschfeld*

Lindsay Hirschfeld, Quality Assurance Manager

Post-It® Fax Note	7671	Date	8/26	# of pages	01
To	<i>CITANTAL</i>	From			
Co./Dept		Co			
Phone #		Phone #			
Fax #	<i>613.632.1053</i>	Fax #			